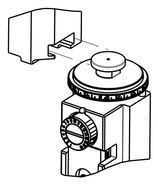
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SET UP GAUGE 2119599-1 | LOC A | DIST 66

REVISIONS

P	LTR	DESCRIPTION	DATE	DWN	APVD
	E7	ECR-15-013464	14SEP2015	YY	UG
	E8	ECR-16-005392	13APR2016	JH	JDG
	E9	ECR-16-009122	27JUN2016	RS	LZ

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151493-1	E	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2151493-2	E	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
2151493-5	E	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE 4
2151493-6	E	NON-CRIMP HEIGHT ADJUST	SERVO LATCH PLATE 4 12
2151493-7	E	FINE CRIMP HEIGHT ADJUST	NONE
7-2151493-7	A	CRIMP TOOLING KIT	-

APPLICATOR STYLE CONVERSION CHART

CONVERT TO	PART NUMBERS REQUIRED					
PNEUMATIC FEED	2119950-1	1338685-1	5-18022-5	2119641-1	2119799-1	2063440-1
SERVO LATCH PLATE	2119951-1	-	8-2151493-5	1901094-3	-	2168400-6 (QUANTITY 2)
SMART APPLICATOR	2161326-1	-	8-2151493-4	-	-	-
MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-1	-	-
SERVO LATCH PLATE	2119951-1	-	8-2151493-5	1901094-3	-	2168400-6 (QUANTITY 2)
SMART APPLICATOR	2161326-1	-	8-2151493-4	-	-	-
MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-1	-	-
PNEUMATIC FEED	2119950-1	1338685-1	5-18022-5	2119641-1	2119799-1	2063440-1
-	-	-	-	-	-	-
-	-	-	-	-	-	-
-	-	-	-	-	-	-

APPLICATOR DATA

CRIMP	SIZE	TYPE
WIRE	1.40 mm [.055]	F
INSUL	1.83 mm [.072]	O

APPLICATOR INSTRUCTIONS 408-10389

TERMINAL DATA: TE TERMINAL — TE CRIMP SPECIFICATION

TERMINAL NAME: MICRO QUADOCK SYSTEM

WIRE STRIP LENGTH	INSULATION DIAMETER RANGE
3.45-3.75 mm [.136-.148 IN]	∅ 1.10-1.60 mm [.043-.063 IN]

TERMINAL APPLICATION SPECIFICATION	(A) 114-18021	-	-
	(B) 114-61024	-	-

TERMINALS APPLIED

GROUP 1 4		GROUP 2 5	
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
(A) 928999-1	(A) 5-928918-2	(A) 968220-1	(A) 1703296-1
(A) 928999-5	(A) 5-928918-1	(A) 968220-5	(A) 1703296-5
(A) 928999-6	(A) 6-928918-1	(A) 968220-6	(A) 1534116-1
(A) 5-928999-1	(A) 6-928918-2	(A) 5-968220-1	(A) 1534116-2
(A) 968893-1	(A) 6-928918-3	(A) 5-968220-5	(A) 5-1534116-1
(A) 928918-1	(A) 1394702-1	(A) 5-968220-6	(A) 5-1534116-2
(A) 928918-2	(A) 1394702-2	(B) 2005119-1	(A) 1241918-1
(A) 1-928918-1	(A) 5-928999-5		
(A) 1-928918-2	(A) 5-928999-6		
(A) 5-1394702-1	(A) 6-928999-5		
(A) 5-1394702-2			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT 9 REFERENCE SETTING
0.35mm2	0.76+/-0.03 [.030+/-.001]	9.9
0.25mm2	0.72+/-0.03 [.028+/-.001]	10.4

TERMINAL DATA: TE TERMINAL — TE CRIMP SPECIFICATION

TERMINAL NAME: MICRO QUADOCK SYSTEM

WIRE STRIP LENGTH	INSULATION DIAMETER RANGE
3.45-3.75 mm [.136-.148 IN]	∅ 1.10-1.60 mm [.043-.063 IN]

TERMINAL APPLICATION SPECIFICATION	(A) 114-18021	-	-
	(B) 114-61024	-	-

TERMINALS APPLIED

GROUP 1 4		GROUP 2 5	
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
(A) 928999-1	(A) 5-928918-2	(A) 968220-1	(A) 1703296-1
(A) 928999-5	(A) 5-928918-1	(A) 968220-5	(A) 1703296-5
(A) 928999-6	(A) 6-928918-1	(A) 968220-6	(A) 1534116-1
(A) 5-928999-1	(A) 6-928918-2	(A) 5-968220-1	(A) 1534116-2
(A) 968893-1	(A) 6-928918-3	(A) 5-968220-5	(A) 5-1534116-1
(A) 928918-1	(A) 1394702-1	(A) 5-968220-6	(A) 5-1534116-2
(A) 928918-2	(A) 1394702-2		(A) 1241918-1
(A) 1-928918-1	(A) 5-928999-5		
(A) 1-928918-2	(A) 5-928999-6		
(A) 5-1394702-1	(A) 6-928999-5		
(A) 5-1394702-2			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT 9 REFERENCE SETTING
0.50mm2	0.86+/-0.03 [.034+/-.001]	9.0

1. RECOMMENDED SPARE PARTS

2. GREASE BEARING SURFACES LIGHTLY

3. LUBRICATE DAILY PER THE APPLICATOR INSTRUCTION SHEET SUPPLIED WITH THE APPLICATOR.

4. APPLICATOR SPECIFIC DATA TO BE ENTERED INTO BLANK MEMORY CHIP AT ASSEMBLY. SEE BELOW FOR PART NUMBER:
   MECHANICAL FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151493-4
   PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151493-4
   SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151493-5
   SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2151493-6

5. ADJUSTMENT OF THE STRIPPER MAY BE REQUIRED WHEN MOVING THE APPLICATOR BETWEEN BENCH AND LEADMAKER APPLICATIONS.

6. APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 62. APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEMS 242. FOR -6 ONLY APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 37.

7. GREASE THREADS, GROOVE AND O-RING ON ITEMS 35 & 252.

8. MAGNET, ITEM 166 MUST BE ORIENTED CORRECTLY IN ORDER TO PROPERLY ACTUATE THE COUNTER.

9. CRIMP HEIGHT REFERENCE SETTING WAS THE SETTING USED WHEN THE APPLICATOR WAS QUALIFIED AT THE FACTORY. ADJUSTMENT MAY BE NECESSARY WHEN RUNNING APPLICATOR IN THE FIELD.

10. SPARE FEED CAM STORAGE LOCATION REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.

11. TO CONVERT THE APPLICATOR TO A NON-CARRIER CUTTING STYLE, REMOVE ITEM 13 AND ATTACH TO THE LOCATION ON THE BACK SIDE OF THE HOUSING. REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.

12. WHEN ASSEMBLING -6 NON-CRIMP HEIGHT ADJUST APPLICATOR USE SHIM PACK 2119957-2 TO ACHIEVE A NOMINAL SHIM HEIGHT OF 1.00m.

13. REFER TO APPLICATION SPECIFICATION,114-18021,PAGE 8,NOTE 3 CONCERNING CRIMPING 0.50mm^2 WIRE.

14. POSITION THE HOLD DOWN, ITEM 18, IN ORIENTATION 1 FOR GROUP 1 TERMINALS. REFER TO SHEET 2.



15. POSITION THE HOLD DOWN, ITEM 18, IN ORIENTATION 2 FOR GROUP 2 TERMINALS. REFER TO SHEET 2.



*WARNING
ON INSTALLATION, SET WIRE DISC, ITEM 40 TO LARGEST WIRE SIZE SETTING. USE OF SETTINGS BELOW MINIMUM REQUIRED CRIMP HEIGHT SETTING WILL CAUSE DAMAGE TO CRIMP TOOLING.

						PART NO	DESCRIPTION	ITEM NO
-	-	1	-	-	-	2119957-2	APPLICATOR SHIM PACK	260
-	1	-	1	1	1	8-21084-0	O-RING, .676 ID, .070 DIA. MAT.	252
-	-	-	-	1	-	2119640-1	PUSH ROD, AIR FEED	250
-	-	-	-	1	-	2079988-1	BUSHING, LCH5-12, MISUMI	249
-	-	-	-	1	-	2119641-1	FEED CAM, AIR FEED	248
-	1	-	1	1	1	2119798-1	DETENT PIN	247
-	1	-	1	1	1	1-22279-3	SPRING, COMPRESSION	246
-	-	1	-	-	-	2119758-1	RAM, AMP STYLE, SIDE FEED, NON-ADJ.	245
-	1	1	1	1	1	2119082-8	CAM, SNAIL, INSULATION ADJUSTMENT	244
-77	-7	-6	-5	-2	-1	PART NO	DESCRIPTION	ITEM NO

						PART NO	DESCRIPTION	ITEM NO
-	1	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
6	-	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	1	1	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	-	2	2	-	-	2168400-6	SHCS, LOW HEAD, RoHS, M5 X 16	240
-	-	-	-	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	-	-	-	1	-	2063440-1	AIR FEED MODULE	238
-	-	1	1	-	-	2119740-2	TAG,IDENTIFICATION	213
-	-	1	1	-	-	1901094-3	SPACER, FEEDER	198
-	-	-	-	2	-	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172
-	1	1	1	1	1	994969-1	MAGNET, RARE EARTH HIGH ENERGY	166
-	REF	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	-	-	-	1	-	240638-1	SPRING, FEED FINGER	163
-	-	-	-	1	-	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	137
-	-	-	-	1	-	2119799-1	HOLDER,FEED FINGER, AF	136
-	-	REF	REF	-	-	SEE NOTE 4	MEMORY CHIP, PROGRAMMED	135
-	-	1	1	-	-	1633743-1	SERVO FEED LATCH ASM	133
-	1	1	1	1	1	1-18028-2	WASHER, FLAT, REG M4	119
-	-	REF	REF	-	-	2119944-1	FEED FINGER ASSEMBLY,SF	117
-	1	1	1	1	1	1-690438-0	FRONT STRIP GUIDE	96
-	2	2	2	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	95
-	1	1	1	1	1	455888-5	SPACER, CRIMPER	82
5 4	-	1	1	1	1	1-240641-3	SPACER	81
-	2	2	2	2	2	1-2079383-0	SCR, BHSC, RoHS (M3 X 6)	79
-	1	1	1	1	1	1633782-2	FENCE	78
-	1	1	1	1	1	2119956-1	DOCUMENTATION PACKAGE	71
-	1	1	1	1	1	2119791-5	DEPRESSOR, WIRE	70
-	1	1	1	1	1	2119943-1	WASHER, SPACER	69
-	1	-	-	1	1	2119740-1	TAG,IDENTIFICATION	67
-	2	2	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	1	-	1	1	1	2119793-1	LIMITER, ADJUSTMENT BOLT	63
6	-	3	-	3	3	3	992763-5	SCR, SET, SOC, CONE POINT, M3 x 4.0	62
-	2	2	2	2	2	2-18032-5	SCR, SET, FLT POINT M5 X 20.0	61
-	1	1	1	1	1	2079383-4	SCR, BHSC, RoHS (M4 X 8)	60
-	-	-	-	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	-	-	-	1	1	1338685-1	PAWL, FEED	56
-	4	4	4	4	4	2168400-1	SHCS, LOW HEAD, RoHS, M4 X 12	54
-	2	2	2	2	2	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	53
-	-	-	-	1	2	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	-	-	-	-	1	2119652-1	FEED CAM, PRE FEED	48
-	-	-	-	-	1	2119653-1	FEED CAM, POST FEED	47
-	1	1	1	1	1	2119656-9	APPLICATOR BASIC ASSEMBLY, SF	46
-	1	-	1	1	1	2119370-1	RAM, AMP STYLE, SIDE FEED	44
-	1	1	1	1	1	2079383-7	SCR, BHSC, RoHS (M8 X 25)	41
-	1	-	1	1	1	2119645-1	DISC, NUMBERED FA WIRE ADJUSTMENT	40
-	1	-	1	1	1	2119957-1	APPLICATOR SHIM PACK	39
-	1	1	1	1	1	2119644-1	RAM WASHER, PRECISION	38
6	-	1	1	1	1	2119085-1	FA HEAD, ATLANTIC STYLE	37
-	1	-	1	1	1	2119092-1	BOLT, ADJUSTMENT	35
-	1	1	1	1	1	1752356-6	SUPPORT, TERMINAL	34
-	2	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	1	1	1	1	1	2161328-1	HEX HEAD, FLANGED, M5 x 8mm LONG	32
-	1	1	1	1	1	1320908-6	SPACER, STRIP GUIDE	30
-	1	1	1	1	1	2119959-3	ASSEMBLY, STRIP GUIDE	29
-	1	1	1	1	1	1-455888-0	SPACER, CRIMPER	28
-	2	2	2	2	2	22283-1	SPRING, COMPRESSION	27
-	1	1	1	1	1	356835-1	LEVER, DRAG RELEASE	26
-	1	1	1	1	1	240792-1	DRAG, TERMINAL	25
-	1	1	1	1	1	1320928-2	STRIP GUIDE	24
-	1	1	1	1	1	980371-4	SCR, SKT HD SHLDR 5.0 DIA X 6.0	23
-	1	1	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
-	1	1	1	1	1	1-18028-2	WASHER, FLAT, REG M4	20
-	1	1	1	1	1	2119533-1	STRIPPER, SIDE FEED	19
5 4	-	1	1	1	1	2217529-1	TERMINAL HOLD DOWN	18
1	-	1	1	1	1	2119806-1	INSERT, SHEAR	13
-	1	1	1	1	1	3-22280-3	SPRING, COMPRESSION	12
-	1	1	1	1	1	1-356885-4	STOP, SHEAR	11
-	1	1	1	1	1	2119805-1	SHEAR HOLDER, FRONT	10
1	-	1	1	1	1	462006-6	FLOATING SHEAR, FRONT	9
1	1	1	1	1	1	1-1338690-2	ANVIL, COMBINATION .055	8
1 5 4	-	1	1	1	1	4-240641-2	SPACER	7
-	1	1	1	1	1	2119757-4	DEPRESSOR, SHEAR	5
-	1	1	1	1	1	238011-8	BLOCK, CRIMPER SPACER	4
1	1	1	1	1	1	2119784-2	CRIMPER, INSULATION O PREMIUM	3
-	1	1	1	1	1	455888-1	SPACER, CRIMPER	2
1	1	1	1	1	1	1-562108-5	CRIMPER, WIRE, F	1
-77	-7	-6	-5	-2	-1	PART NO	DESCRIPTION	ITEM NO

ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

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DWN L GROSS 02SEP2011
CHK G BAILEY 02SEP2011
APVD T CRUZ 02SEP2011
PRODUCT SPEC -
APPLICATION SPEC -
WEIGHT -

DIMENSIONS: mm
TOLERANCES UNLESS OTHERWISE SPECIFIED:
0 PLC ±
1 PLC ±
2 PLC ±
3 PLC ±
4 PLC ±
ANGLES ±
MATERIAL - -
FINISH - -

TE Connectivity
Harrisburg, PA 17105-3608

NAME Ocean Side Feed Applicator -

SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
A1	00779	C-2151493	-

Customer Accessible Production Drawing | SCALE 5:1 | SHEET 1 OF 4 | REV E9

SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

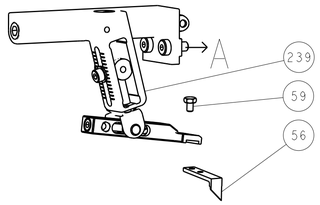
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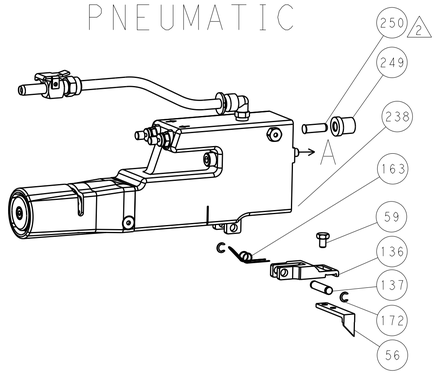
REVISIONS

P	LTR	DESCRIPTION	DATE	DWN	APVD
	-	SEE SHEET 1	-	-	-

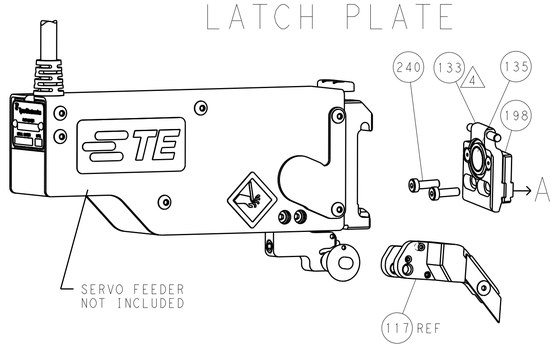
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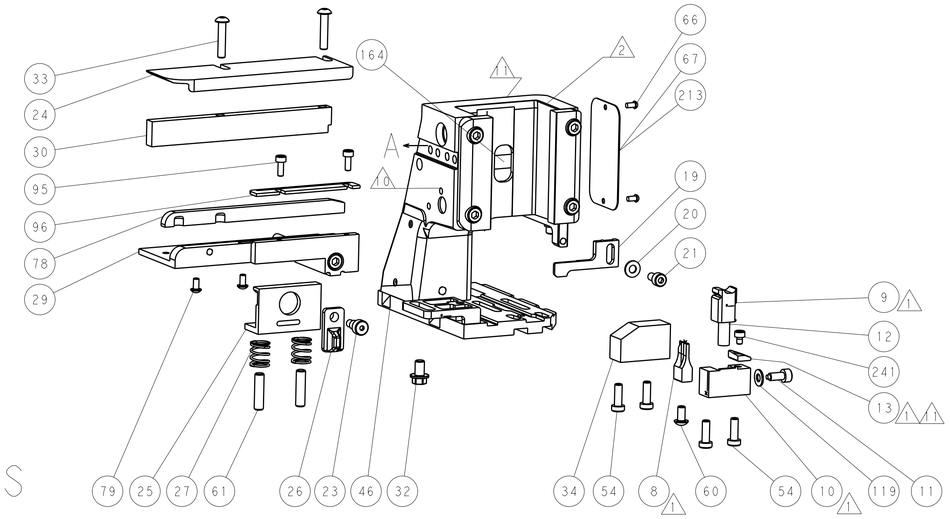


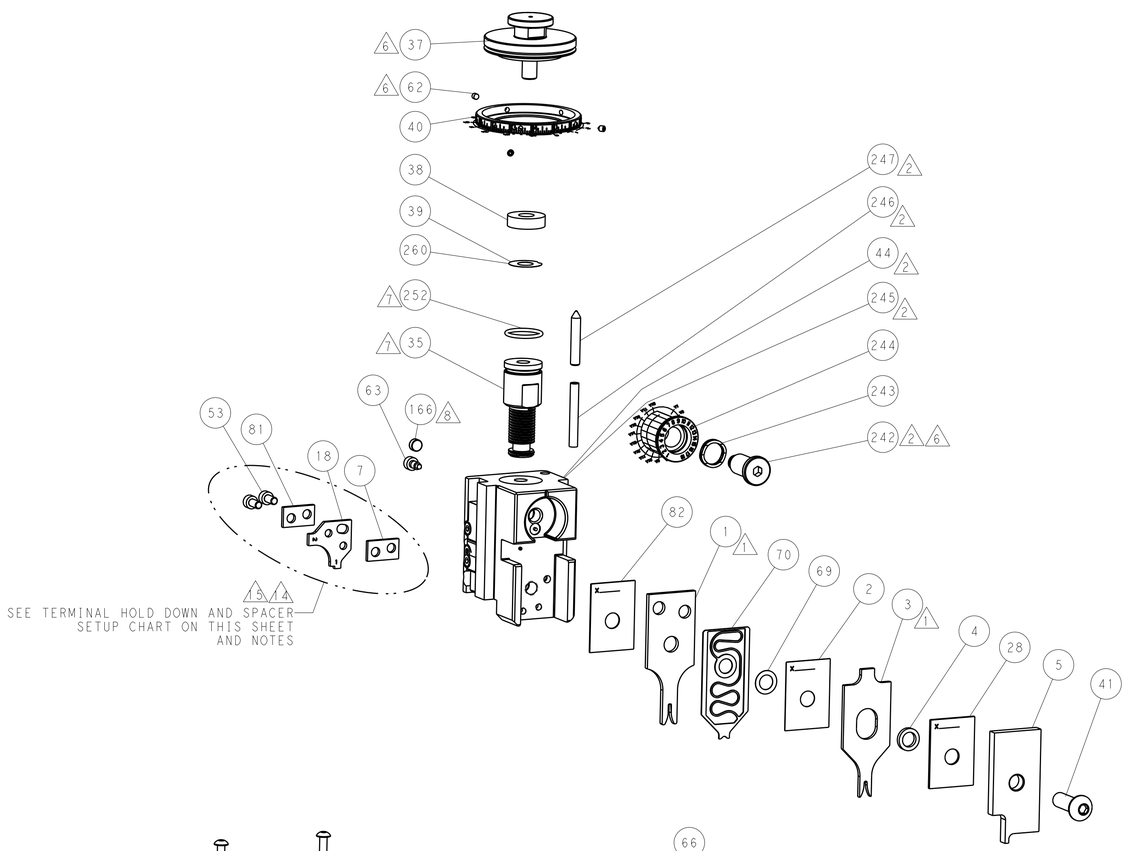
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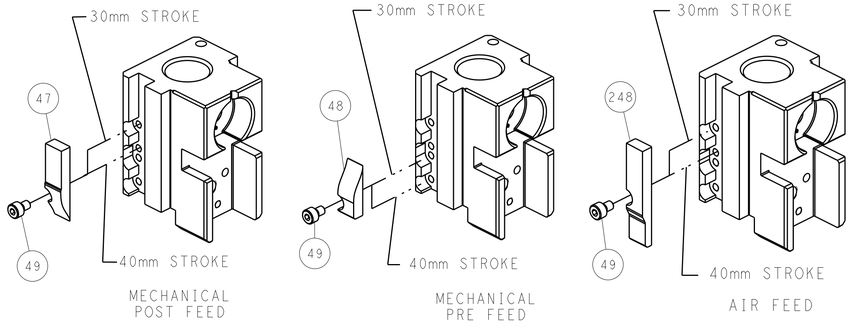
SERVO LATCH PLATE



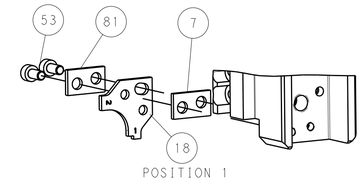
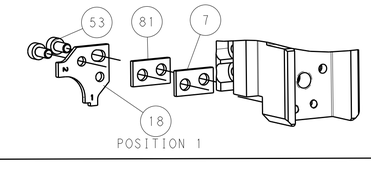
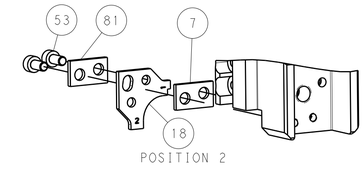
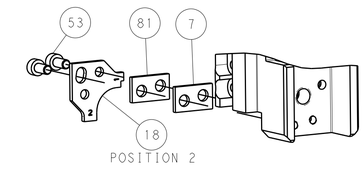


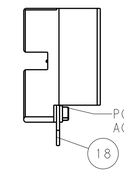


CAM POSITIONS

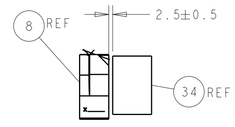


TERMINAL HOLD DOWN & SPACER SETUP CHART

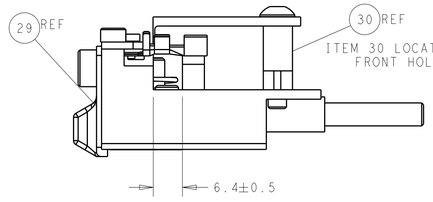
GROUP 1 4	HOLD DOWN & SPACER TOOLING SETUP FOR TERMINALS: 928999-1, 928999-5, 928999-6, 5-928999-1, 6-928999-5, 928918-1, 928918-2, 1-928918-1, 1-928918-2, 2-928918-2, 3-928918-2, 5-928918-1, 6-928918-1, 6-928918-2, 6-928918-3, 1394702-1, 1394702-2, 5-1394702-1, 5-1394702-2	 POSITION 1
	HOLD DOWN & SPACER TOOLING SETUP FOR TERMINALS: 968893-1	 POSITION 1
GROUP 2 5	HOLD DOWN & SPACER TOOLING SETUP FOR TERMINALS: 968220-1, 968220-5, 968220-6, 5-968220-1, 5-968220-5, 5-968220-6, 1703296-1, 1703296-5, 1534116-1, 1534116-2, 5-1534116-1	 POSITION 2
	HOLD DOWN & SPACER TOOLING SETUP FOR TERMINALS: 1241918-1	 POSITION 2



HOLD DOWN SETUP



TERMINAL SUPPORT LOCATION



FEED TRACK POSITION
GUIDE BY INSULATION BARREL

ATLANTIC VERSION

Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

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DIMENSIONS: mm

TOLERANCES UNLESS OTHERWISE SPECIFIED:
0 PLC ±
1 PLC ±
2 PLC ±
3 PLC ±
4 PLC ±
ANGLES ±

MATERIAL -
FINISH -

DWN	L GROSS	02SEP2011
CHK	G BAILEY	02SEP2011
APVD	L CRUZ	02SEP2011
PRODUCT SPEC	-	
APPLICATION SPEC	-	
WEIGHT	-	

TE Connectivity
Harrisburg, PA 17105-3608

NAME: Ocean Side Feed Applicator -

SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
A1	00779	C-2151493	-

Customer Accessible Production Drawing | SCALE 5:1 | SHEET 2 OF 4 | REV E9

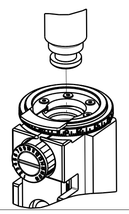
SHEETS 3 & 4 ARE NOT REQUIRED FOR ATLANTIC VERSION

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SET UP GAUGE 2119599-1 | LOC A | DIST 66

REVISIONS

P	LTR	DESCRIPTION	DATE	DWN	APVD
	-	SEE SHEET 1	-	-	-

PACIFIC VERSION TERMINATOR INTERFACE ADAPTER	PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
	2-2151493-1	E	FINE CRIMP HEIGHT ADJUST	MECHANICAL
	2-2151493-2	E	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
	2-2151493-5	E	FINE CRIMP HEIGHT ADJUST	SERVO LATCH PLATE 4
	2-2151493-7	E	FINE CRIMP HEIGHT ADJUST	NONE
	7-2151493-7	A	CRIMP TOOLING KIT	-

APPLICATOR STYLE CONVERSION CHART

CONVERT TO	PART NUMBERS REQUIRED					
PNEUMATIC FEED	2119950-1	1338685-1	5-18022-5	2119641-1	2119799-1	2063440-1
SERVO LATCH PLATE	2119951-1	-	8-2151493-5	1901094-3	-	2168400-6 (QUANTITY 2)
SMART APPLICATOR	2161326-1	-	8-2151493-4	-	-	-
MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-1	-	-
SERVO LATCH PLATE	2119951-1	-	8-2151493-5	1901094-3	-	2168400-6 (QUANTITY 2)
SMART APPLICATOR	2161326-1	-	8-2151493-4	-	-	-
MECHANICAL FEED	2119949-1	1338685-1	5-18022-5	2119653-1	-	-
PNEUMATIC FEED	2119950-1	1338685-1	5-18022-5	2119641-1	2119799-1	2063440-1

APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.40 mm [.055]	F
INSUL	1.83 mm [.072]	O
APPLICATOR INSTRUCTIONS 408-10389		

TERMINAL DATA: TE TERMINAL — TE TE CRIMP SPECIFICATION
TERMINAL NAME: MICRO QUADOCK SYSTEM

WIRE STRIP LENGTH 3.45-3.75 mm [.136-.148 IN]	INSULATION DIAMETER RANGE ∅1.10-1.60 mm [.043-.063 IN]
TERMINAL APPLICATION SPECIFICATION (A) 114-18021	-
(B) 114-61024	-

TERMINALS APPLIED

GROUP 1 13		GROUP 2 14	
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
(A) 928999-1	(A) 5-928918-2	(A) 968220-1	(A) 1703296-1
(A) 928999-5	(A) 5-928918-1	(A) 968220-5	(A) 1703296-5
(A) 928999-6	(A) 6-928918-1	(A) 968220-6	(A) 1534116-1
(A) 5-928999-1	(A) 6-928918-2	(A) 5-968220-1	(A) 1534116-2
(A) 968893-1	(A) 6-928918-3	(A) 5-968220-5	(A) 5-1534116-1
(A) 928918-1	(A) 1394702-1	(A) 5-968220-6	(A) 5-1534116-2
(A) 928918-2	(A) 1394702-2	(B) 2005119-1	(A) 1241918-1
(A) 1-928918-1	(A) 5-928999-5		
(A) 1-928918-2	(A) 5-928999-6		
(A) 5-1394702-1	(A) 6-928999-5		
(A) 5-1394702-2			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT 9 REFERENCE SETTING
0.35mm2	0.76+/-0.03 [.030+/-.001]	9.9
0.25mm2	0.72+/-0.03 [.028+/-.001]	10.4

TERMINAL DATA: TE TERMINAL — TE CRIMP SPECIFICATION
TERMINAL NAME: MICRO QUADOCK SYSTEM

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TERMINAL APPLICATION SPECIFICATION (A) 114-18021	-
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TERMINALS APPLIED

GROUP 1 13		GROUP 2 14	
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
(A) 928999-1	(A) 5-928918-2	(A) 968220-1	(A) 1703296-1
(A) 928999-5	(A) 5-928918-1	(A) 968220-5	(A) 1703296-5
(A) 928999-6	(A) 6-928918-1	(A) 968220-6	(A) 1534116-1
(A) 5-928999-1	(A) 6-928918-2	(A) 5-968220-1	(A) 1534116-2
(A) 968893-1	(A) 6-928918-3	(A) 5-968220-5	(A) 5-1534116-1
(A) 928918-1	(A) 1394702-1	(A) 5-968220-6	(A) 5-1534116-2
(A) 928918-2	(A) 1394702-2		(A) 1241918-1
(A) 1-928918-1	(A) 5-928999-5		
(A) 1-928918-2	(A) 5-928999-6		
(A) 5-1394702-1	(A) 6-928999-5		
(A) 5-1394702-2			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT 9 REFERENCE SETTING
0.50mm2 12	0.86+/-0.03 [.034+/-.001]	9.0

1 RECOMMENDED SPARE PARTS

2 GREASE BEARING SURFACES LIGHTLY

3. LUBRICATE DAILY PER THE APPLICATOR INSTRUCTION SHEET SUPPLIED WITH THE APPLICATOR.

4 APPLICATOR SPECIFIC DATA TO BE ENTERED INTO BLANK MEMORY CHIP AT ASSEMBLY. SEE BELOW FOR PART NUMBER:
MECHANICAL FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151493-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2151493-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2151493-5

5. ADJUSTMENT OF THE STRIPPER MAY BE REQUIRED WHEN MOVING THE APPLICATOR BETWEEN BENCH AND LEADMAKER APPLICATIONS.

6 APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEMS 62. APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEMS 242.

7 GREASE THREADS, GROOVE AND O-RING ON ITEMS 139 & 152.

8 MAGNET MUST BE ORIENTED CORRECTLY IN ORDER TO PROPERLY ACTUATE THE COUNTER.

9 CRIMP HEIGHT REFERENCE SETTING WAS THE SETTING USED WHEN THE APPLICATOR WAS QUALIFIED AT THE FACTORY. ADJUSTMENT MAY BE NECESSARY WHEN RUNNING APPLICATOR IN THE FIELD.

10 SPARE FEED CAM STORAGE LOCATION REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.

11 TO CONVERT THE APPLICATOR TO A NON-CARRIER CUTTING STYLE, REMOVE ITEM 13 AND ATTACH TO THE LOCATION ON BACK SIDE OF THE HOUSING. REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.

12 REFER TO APPLICATION SPECIFICATION,114-18021,PAGE 8,NOTE 3 CONCERNING CRIMPING 0.50mm^2 WIRE.

13 POSITION THE HOLD DOWN, ITEM 18, IN ORIENTATION 1 FOR GROUP 1 TERMINALS. REFER TO SHEET 4.



14 POSITION THE HOLD DOWN, ITEM 18, IN ORIENTATION 2 FOR GROUP 2 TERMINALS. REFER TO SHEET 4.



*WARNING
ON INSTALLATION, SET WIRE DISC, ITEM 40 TO LARGEST WIRE SIZE SETTING. USE OF SETTINGS BELOW MINIMUM REQUIRED CRIMP HEIGHT SETTING WILL CAUSE DAMAGE TO CRIMP TOOLING.

-	1	1	1	1	2119782-1	FINE ADJUST HEAD ASM, PACIFIC STYLE	251
-	-	-	1	-	2119640-1	PUSH ROD, AIR FEED	250
-	-	-	1	-	2079988-1	BUSHING, LCH5-12, MISUMI	249
-	1	1	1	1	1-22279-3	SPRING, COMPRESSION	246
-	1	1	1	1	2119082-8	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
6 -	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	1	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	-	2	-	-	2168400-6	SHCS, LOW HEAD, RoHS, M5 X 16	240
-77	-27	-25	-22	-21	PART NO	DESCRIPTION	ITEM NO

-	-	-	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	-	-	1	-	2063440-1	AIR FEED MODULE	238
-	-	1	-	-	2119740-2	TAG,IDENTIFICATION	213
-	-	1	-	-	1901094-3	SPACER, FEEDER	198
-	-	-	2	-	21045-3	RING, RETAIN, EXTERN, 3/16 CRESCENT	172
-	1	1	1	1	994969-1	MAGNET, RARE EARTH HIGH ENERGY	166
-	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	-	-	1	-	240638-1	SPRING, FEED FINGER	163
-	1	1	1	1	8-21084-1	O-RING, .801 ID, .070 DIA. MAT.	152
-	-	-	1	-	2119641-2	FEED CAM, AIR FEED	151
-	1	1	1	1	2119798-2	DETENT PIN	145
-	1	1	1	1	2079383-8	SCR, BHSC, RoHS (M4 X 16)	144
-	4	4	4	4	2168400-5	SHCS, LOW HEAD, RoHS, M4 X 20	143
-	-	-	-	1	2119653-2	FEED CAM, POST FEED	142
-	1	1	1	1	1-2119656-0	APPLICATOR BASIC ASSEMBLY, SF	141
-	1	1	1	1	2119650-1	RAM, ASIAN STYLE, SIDE FEED	140
-	1	1	1	1	2119092-2	BOLT, ADJUSTMENT	139
-	-	-	1	-	3-23627-7	PIN, RETAIN, GRVD, 3/16 X .854	137
-	-	-	1	-	2119799-1	HOLDER,FEED FINGER, AF	136
-	-	REF	-	-	SEE NOTE 4	MEMORY CHIP, PROGRAMMED	135
-	-	1	-	-	1633743-1	SERVO FEED LATCH ASM	133
-	1	1	1	1	1-18028-2	WASHER, FLAT, REG M4	119
-	-	REF	-	-	2119944-1	FEED FINGER ASSEMBLY,SF	117
-	1	1	1	1	1-690438-0	FRONT STRIP GUIDE	96
-	2	2	2	2	2168083-1	SCR, SKT HD CAP, RoHS, M3 X 8.0	95
-	1	1	1	1	455888-5	SPACER, CRIMPER	82
14 13 -	1	1	1	1	1-240641-3	SPACER	81
-	2	2	2	2	1-2079383-0	SCR, BHSC, RoHS (M3 X 6)	79
-	1	1	1	1	1633782-2	FENCE	78
-	1	1	1	1	2119956-1	DOCUMENTATION PACKAGE	71
-	1	1	1	1	2119791-5	DEPRESSOR, WIRE	70
-	1	1	1	1	2119943-1	WASHER, SPACER	69
-	1	-	1	1	2119740-1	TAG,IDENTIFICATION	67
-	2	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	1	1	1	1	2119793-1	LIMITER, ADJUSTMENT BOLT	63
6 -	3	3	3	3	992763-5	SCR, SET, SOC, CONE POINT, M3 x 4.0	62
-	2	2	2	2	2-18032-5	SCR, SET, FLT POINT M5 X 20.0	61
-	-	-	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	-	-	1	1	1338685-1	PAWL, FEED	56
-	2	2	2	2	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	53
-	-	-	1	2	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	-	-	-	1	2119652-1	FEED CAM, PRE FEED	48
-	1	1	1	1	2079383-7	SCR, BHSC, RoHS (M8 X 25)	41
-	1	1	1	1	2119645-1	DISC, NUMBERED FA WIRE ADJUSTMENT	40
-	1	1	1	1	2119957-1	APPLICATOR SHIM PACK	39
-	1	1	1	1	2119644-1	RAM WASHER, PRECISION	38
-	1	1	1	1	1752356-6	SUPPORT, TERMINAL	34
-	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	1	1	1	1	2161328-1	HEX HEAD, FLANGED, M5 x 8mm LONG	32
-	1	1	1	1	1320908-6	SPACER, STRIP GUIDE	30
-	1	1	1	1	2119959-3	ASSEMBLY, STRIP GUIDE	29
-	1	1	1	1	1-455888-0	SPACER, CRIMPER	28
-	2	2	2	2	22283-1	SPRING, COMPRESSION	27
-	1	1	1	1	356835-1	LEVER, DRAG RELEASE	26
-	1	1	1	1	240792-1	DRAG, TERMINAL	25
-	1	1	1	1	1320928-2	STRIP GUIDE	24
-	1	1	1	1	980371-4	SCR, SKT HD SHLDR 5.0 DIA X 6.0	23
-	1	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
-	1	1	1	1	1-18028-2	WASHER, FLAT, REG M4	20
-	1	1	1	1	2119533-1	STRIPPER, SIDE FEED	19
14 13 -	1	1	1	1	2217529-1	TERMINAL HOLD DOWN	18
1 -	1	1	1	1	2119806-1	INSERT, SHEAR	13
-	1	1	1	1	3-22280-3	SPRING, COMPRESSION	12
-	1	1	1	1	1-356885-4	STOP, SHEAR	11
-	1	1	1	1	2119805-1	SHEAR HOLDER, FRONT	10
1 -	1	1	1	1	462006-6	FLOATING SHEAR, FRONT	9
1 1	1	1	1	1	1-1338690-2	ANVIL, COMBINATION .055	8
14 13 -	1	1	1	1	4-240641-2	SPACER	7
-	1	1	1	1	2119757-4	DEPRESSOR, SHEAR	5
-	1	1	1	1	238011-8	BLOCK, CRIMPER SPACER	4
1 1	1	1	1	1	2119784-2	CRIMPER, INSULATION O PREMIUM	3
-	1	1	1	1	455888-1	SPACER, CRIMPER	2
1 1	1	1	1	1	1-562108-5	CRIMPER, WIRE, F	1
	-77	-27	-25	-22	-21 PART NO	DESCRIPTION	ITEM NO

PACIFIC VERSION

Shown on sheets 3 of 4 & 4 of 4
(Atlantic version shown on sheets 1 of 4 & 2 of 4)

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TE Connectivity
Harrisburg, PA 17105-3608

NAME: Ocean Side Feed Applicator -

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Customer Accessible Production Drawing | SCALE 5:1 | SHEET 3 OF 4 | REV E9

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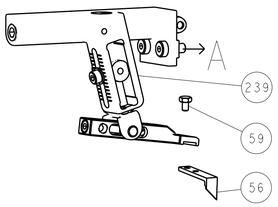
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REVISIONS

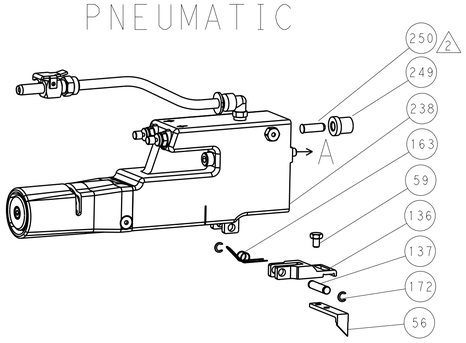
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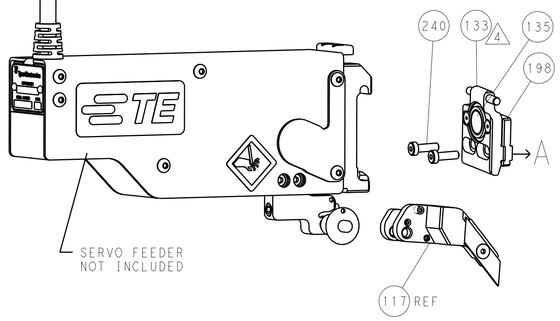
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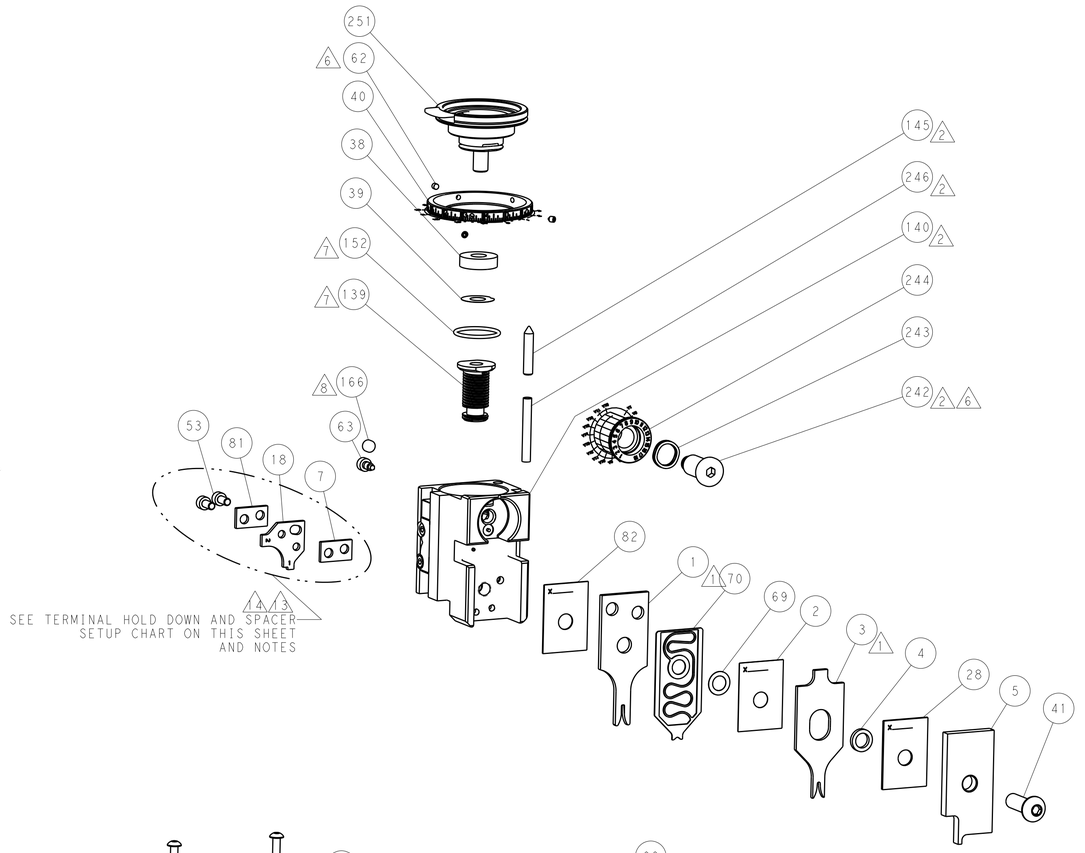


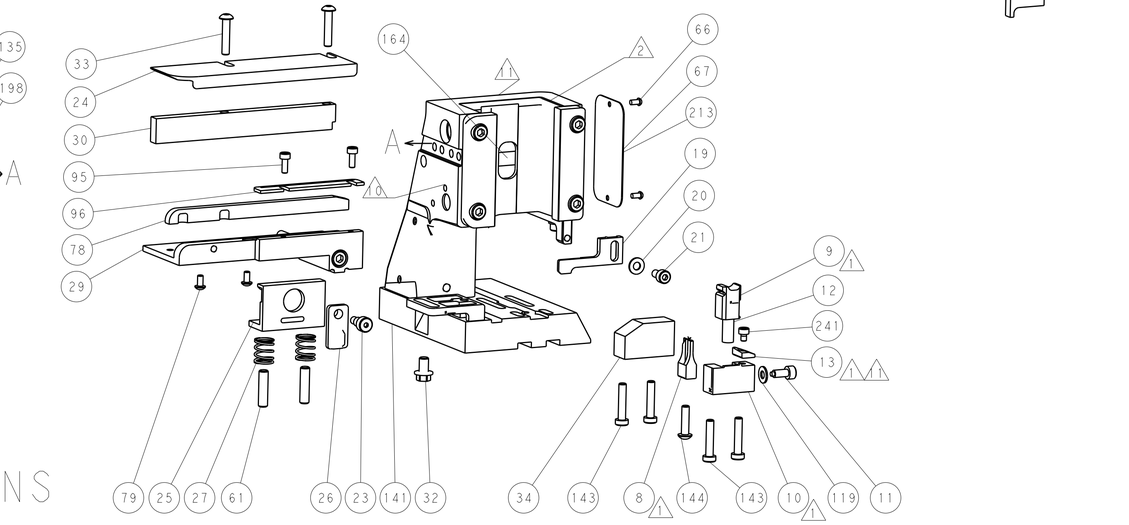
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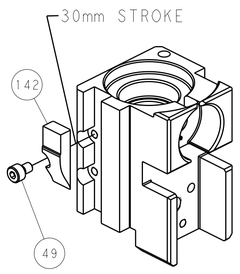
SERVO LATCH PLATE



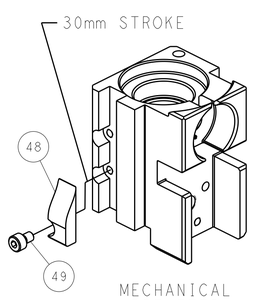




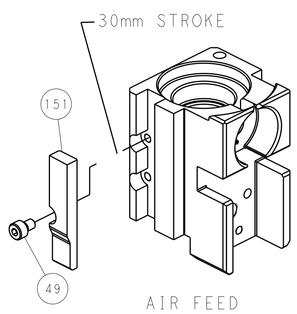
CAM POSITIONS



MECHANICAL POST FEED



MECHANICAL PRE FEED



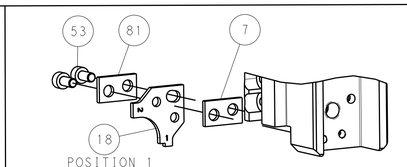
AIR FEED

TERMINAL HOLD DOWN AND SPACER SETUP CHART

GROUP 1 △3

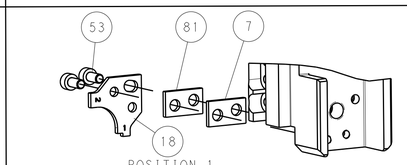
HOLD DOWN & SPACER TOOLING SETUP FOR TERMINALS:

928999-1	2-928918-2
928999-5	3-928918-2
928999-6	5-928918-1
5-928999-1	6-928918-1
6-928999-5	6-928918-2
928918-1	6-928918-3
928918-2	1394702-1
1-928918-1	1394702-2
1-928918-2	5-1394702-1
	5-1394702-2



HOLD DOWN & SPACER TOOLING SETUP FOR TERMINALS:

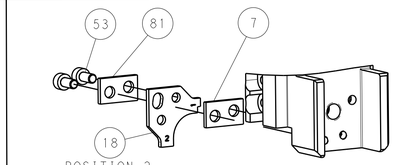
968893-1



GROUP 2 △4

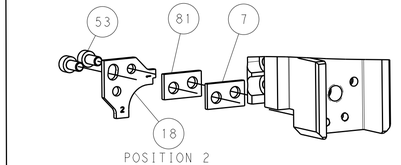
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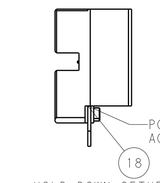
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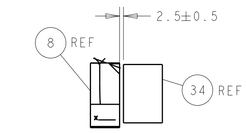
HOLD DOWN & SPACER TOOLING SETUP FOR TERMINALS:

1241918-1

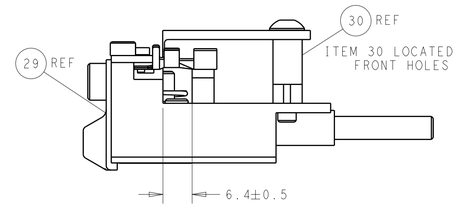




HOLD DOWN SETUP



TERMINAL SUPPORT LOCATION



FEED TRACK POSITION GUIDE BY INSULATION BARREL

PACIFIC VERSION

Shown on sheets 3 of 4 & 4 of 4

(Atlantic version shown on sheets 1 of 4 & 2 of 4)

THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION IT IS SUBJECT TO CHANGE AND THE CONTROLLING ENGINEERING ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST REVISION.

DIMENSIONS: mm

TOLERANCES UNLESS OTHERWISE SPECIFIED:
0 PLC ±
1 PLC ±
2 PLC ±
3 PLC ±
4 PLC ±
ANGLES ±

MATERIAL -
FINISH -

DWN	L GROSS	02SEP2011
CHK	G BAILEY	02SEP2011
APVD	L CRUZ	02SEP2011
PRODUCT SPEC	-	
APPLICATION SPEC	-	
WEIGHT	-	

TE Connectivity
Harrisburg, PA 17105-3608

NAME: Ocean Side Feed Applicator -

SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
A1	00779	C-2151493	-

Customer Accessible Production Drawing | SCALE 5:1 | SHEET 4 OF 4 | REV E9

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION